

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002519**Date Inspected:** 14-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use: Yes No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed: Yes No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up: Yes No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS: Yes No N/A
				Delayed / Cancelled: Yes No N/A
Bridge No:	34-0006	Component:	OBG Deck Panels	

Summary of Items Observed:

CALTRANS Quality Assurance (QA) Inspector, Erik Prue was present for the fabrication scheduled for this project at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge.

Tower Bay 3, New OBG Bay 1: QA inspector performed ultrasonic testing (UT) verification before ZPMC Quality Control (QC) UT inspections on partial penetration joints of deck panels DP-080-001 weld joints 9 & 10, DP085-001 weld joint 3, and DP490-001 weld joint 3. QA UT inspected 15% of the total weld length of weld joints listed above. QA Inspector found lack of penetration indications that results in depth of penetration less than the minimum of 9.6 mm required on weld joints for deck panels DP080-001 and DP490-001. Area inspected by QA UT Inspector for DP085-001 contained no areas of depth of penetration less than the required 9.6 mm. QA inspector performed ultrasonic testing (UT) verification after ZPMC Quality Control (QC) UT inspection on partial penetration joints of the deck panel DP-018-002 to the U-Rib weld joints 7 & 8. QC UT inspected 15% of the total weld length of each weld joint. QA UT Inspector inspected 100% of required 15% QC UT inspection per weld joint. QA UT Inspector verified ZPMC QC UT findings of no depth of penetration less than the required 9.6 mm. For details on UT inspections see modified TL-6027 UT Inspection reports dated 14 May, 2008.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No significant conversations this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry, 858 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
